

AMENDMENTS TO THE CLAIMS

16. **(Currently Amended)** A manufacturing method for an injection-molded and in-mold decorated article, comprising:

setting a decorating film between a first mold element and a second mold element placed in opposition to each other so that a molding space is defined by the decorating film and the first mold element, the molding space ~~including comprising~~ a product molding space, a resin-injection-use molding space, which is formed adjacent to at least part of the product molding space, with a gate portion through which molding resin is injected from outside of the molding space, and a resin-discharging-use molding space, ~~which is formed so as to be adjacent to and communicative with at least part of a periphery of the product molding space, and into which molten the molding resin is let to flow for discharge of the molding resin from the product molding space from the product molding space flows;~~

injecting the molding resin through the gate portion into the resin-injection-use molding space, thereby filling the resin-injection-use molding space with the molding resin as it flows radially outward from the gate portion and into the product molding space;

~~injecting the molten molding resin into the product molding space;~~

discharging part of the ~~injected~~ molding resin from the product molding space into the resin-discharging-use molding space as the molding resin continues to flow radially outward from the gate portion;

filling the molding space with the molding resin until complete; and completing filling of the molding resin into the product molding space and the resin-discharging-use molding space;
and

solidifying the molding resin ~~filled~~ in the molding space while decorating a surface of the molding resin with the decorating film, so that the injection-molded and in-mold decorated article is manufactured.

17-19. (Cancelled)

20. (Currently Amended) The manufacturing method for the injection-molded and in-mold decorated article as defined in Claim 16, wherein the injection of the molding resin is performed in a state that, with the decorating film placed between the first mold element and the second mold element, the first mold element and the second mold element are clamped to make the molding space hermetically closed.

21. (Currently Amended) The manufacturing method for the injection-molded and in-mold decorated article as defined in Claim 20, further comprising compressing the molding resin in the molding space by reducing the capacity of the molding space, after filling the molding space with the molding resin, wherein, after the filling of the molding resin into the molding space, a capacity of the molding space is reduced while compressing the filled molding resin.

22. (Currently Amended) The manufacturing method for the injection-molded and in-mold decorated article as defined in Claim 16, wherein, the injecting of the molding resin is performed when with the decorating film is placed set between the first mold element and the second mold element, placed in opposition to each other and making the first mold element and the second mold element approached by each other so as to be in a condition such that the molding space is opened, the injection of the molding resin is performed, and thereafter subsequently clamping the first mold element and the second mold element, thereby compressing the molding resin in the molding space by reducing the capacity of the molding space, is clamped so that a capacity of the molding space is reduced while compressing the filled molding resin.

23. (Withdrawn-Currently Amended) A mold for injection molding with in-mold decoration for manufacturing an injection-molded and in-mold decorated article, the mold comprising:

a first mold element; and

a second mold element ~~which is placed in opposition to the first mold element with; and setting-~~

a decorating film located between the both first and second mold elements and forming a molding space between the first mold element and the decorating film,

the first mold element comprising:

a product molded article forming portion ~~which is comprising~~ a recessed portion, formed on a surface of the first mold element, for defining a product molding space between the product molded article forming portion and the decorating film; ~~with setting between the elements, the product molding space is part of a molding space and into which molten molding resin is injected; and~~

an injection-space molded article forming portion comprising a recessed portion, formed on the surface of the first mold element and adjacent to at least part of the product molded article forming portion, for defining a resin-injection-use molding space between the injection-space molded article forming portion and the decorating film, and having a gate portion for injecting the molding resin into the resin-injection-use molding space, thereby filling the resin-injection-use molding space with the molding resin as it flows radially outward from the gate portion and into the product molding space;

a discharge-space molded article forming portion ~~which is comprising~~ a recessed portion, formed on the surface of the first mold element adjacent to at least part of the product molding space, for defining a resin-discharging-use molding space between the discharge-space molded article forming portion and the decorating film, ~~with setting between the elements, the resin-discharging-use molding space is part of the molding space and is formed so as to be adjacent to and communicative with at least part of a periphery of the product molding space and into which part of the molding resin injected into the product molding space is let to flow and discharged-~~ from the product molding space from the product molding space flows as it continues to flow radially outwards, filling the molding space, wherein

~~with defining the product molding space and the resin-discharging-use molding space by~~

setting the decorating film between the both mold elements, part of the molding resin injected into the product molding space is discharged from the product molding space into the resin-discharging-use molding space, and then the molding resin filled in the product molding space and the resin-discharging-use molding space is solidified while decorating a surface of the molding resin is decorated with the decorating film, so that the injection-molded and in-mold decorated article is manufactured.

24-25. (Cancelled)

26. (Withdrawn-Currently Amended) The mold for manufacturing an injection-molded and in-mold decorated article of injection-molding with in-mold decoration as defined in Claim 23, further comprising a film holding portion ~~which is formed as generally comprising a~~ protruded portion on a surface of the second mold element, for holding and stretching, with ~~which the decorating film in the resin-discharging-use molding space is to be brought into contact by the injection of the molding resin into the resin-discharging-use molding space, and which serves to hold placement of the decorating film while removing looseness of the~~ decorating film by putting the decorating film into close contact with a surface of the protruded portion during the injection of the molding resin into the molding space.

27. (Withdrawn-Currently Amended) The mold for manufacturing an injection-molded and in-mold decorated article of injection-molding with in-mold decoration as defined in Claim 26, further comprising a plurality of suction portions ~~which are set at located in or near the film holding portion or its vicinities in on~~ the surface of the second mold element and which serve for sucking and holding the decorating film in contact therewith with the second mold element.

28. (Withdrawn-Currently Amended) The mold for manufacturing an injection-molded and in-mold decorated article of injection-molding with in-mold decoration as defined in Claim 23, wherein either ~~one of~~ the first mold element or the second mold element further

~~comprising~~comprises:

a recess portion formed along ~~an entirety or part of at least part of~~ an outer periphery of the molding space ~~thereon~~; and

a protruded engagement portion, ~~opposed to a placement of the recess portion, which is formed on either the first or second mold element the other of the first mold element or the second mold element so as to correspond to the placement of the recessed portion and such that the protruded engagement portion engages~~ engage with the recess portion in the clamping state of ~~the first mold element and the second mold element~~ when the first and second mold elements are clamped, wherein

~~when the first and second mold elements are clamped with the decorating film, in the clamping state of the first mold element and the second mold element with the decorating film interposed therebetween,~~ tension is imparted to the decorating film by making the recessed portion and the engagement portion engaged with each other via the decorating film.

29. (Withdrawn-Currently Amended) The mold for manufacturing an injection-molded and in-mold decorated article of injection molding with in-mold decoration as defined in Claim 23, further comprising an air vent portion, located near an edge of the product molding space for discharging gas present in the ~~resin-discharging-use molding space, to outside of the molding space~~ in a vicinity of a boundary with the product molding space in the resin-discharging-use molding space.

30. (Cancelled)